110

QC2-Inspect parts off machine FAI/FAIB

2-Deburr if necessary

0.00

\*110\*

Quality Control

Memo

0.00

4 0

JM13.2-8

NCR: Yes / No

### WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	*

											QA Closed:	Date	11		
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
	17	11-11			Rework			Skid-tube Crosstube Water Jet Eng							
Part No					Scrap			Machining	Small Fab	_		d. Eng. Coor.		Quality	
					Use-as-is			noforming	Finishing	_	Rec/Sto	re/Packaging		Other	
NCR No					Work Order Update			Large Fab	Composite			Supplier		-1-27	
Root				Descri	ption of work order update	In	itial	A	ction		Sign &	TOTAL STATE	T	A	
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Des	cription		Date	Verification		QC Inspector	
Doc/Data												THE WALL			
Equip/Tooling															
Operator	1												1		
Material	_											1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			
Setup	-											×	-	7	
Cither	-											tu 5			
Process	+	İ													
Supplier	-									٠,					
Training Unapproved	-	i i										of the second			
unapproved					C	ALILI	CATE	GORY		-		A Trans	7		
Landing	Gear				General	MUL	CAIL	CONT					5-1		
	Bending				Bend		Grain		1		Ovalized		7 <sub>P</sub>	ressure/Forced	
	Centre No	t Concer	tric to 0	o/s	BOM/Route		Hardwa	ire		_	Over/Under	tolerance	_	emperature/Cure	
	Cracks				Broken/Damaged	-		ion Incomplete			Part Incorre	San Of State of	_	Veld	
	Crushed/0	Crimped.			Burrs	-		ions Incomplete	/Unclear		Part Lost/M	lissing	V	Vrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance			Part Moved	PALL .			
Heat Treat Countersink							Mislabe	eled			Positioned \	Wrong			
	Inspection	Strip in	Tube		Cut Too Short		Misrea	d			Power Loss,	/Surge	C	Other	
	Ripples in	Bend			Drill Holes		Offset					W			
	Torque W	aves in E	xtrusion	1	Drawing		Out of Calibration								
	Turning S	equence			Finish		Out of Sequence								
	Wave/Tw	ist in Tub	ne.		Folio		Outside	Dimensions				4.7 Table 1			

January-16-13 8:34:24 AM

Item ID:

Required Date: 1/30/13

D4004-041

Revision ID:

Side Restraint Angle Item Name:

Start Date:

1/16/13

QC:

Start Qty: 4.00 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Accept

Date: Date:

\*N900040100\*

Run

Start Stop

Sequence ID/ Work Center ID

120

\*120\*

QC

Quality Control

Operation Description

QC8- Inspect parts - second cheek

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Setup Start

Reject Insp. Number

Stamp

130

\*130\*

Brake NC

Bend as per dwg

0.00

Brake NC

1- Bend D4004-1 as per Dwg

0.00

2- C'sink as per dwg

140

QC

QC5- Inspect part completeness to step on W/O

0.00 SMB 0.00 /3.2-13

Quality Control

\*140\*

Memo

Memo

NCR: \	Yes	/ No				WORK ORDER NON-C	ON	IFORM	MANCE / UPDATE	QA CI	osed:	() ( Date:	12/3/210
Work Orde	er:	9	564	7		DISPOSITION		, ( )					
Part N	Part No. <u>D 4004-041</u> NCR No. <u>13-2419</u>					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube  Machining Small Fab  noforming Finishing  Large Fab Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root		D-1	61	01	25	ption of work order update or Non-conformance		nitial ef Eng	Action	Sign	ATTEN	Verification	QC Inspector
Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	+	Date	20	Qty	pass on	was foun in the wrong way debut mechane and Error.	05	AS 16 2012 13/16	Description  Scap & destroy  No replace  # 45.20	Da So 1 Nor		10AS 16 1 3.6 1 13 log lus	(DAS) 16 28 032002 13/13/16
2.0		-2					AULT	T CATE	GØRY		hand)	tent of the	
Landii		Bending Centre No Cracks Crushed/C Cuffs Heat Trea	Crimped.		0/5	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short			ion Incomplete ions Incomplete/Unclear enance	Part In Part L Part N Position	Under ncorrect ost/Mi	tolerance ct ssing vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
A CONTRACTOR		Ripples in	Bend			Drill Holes		Offset		1 34			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Page 3

Insp.

Work Order ID 95647 \*95647\* January-16-13 8:34:24 AM Item ID: D4004-041 Accept \*N900040100\* Setup Start Revision ID: Item Name: Side Restraint Angle Start Date: 1/16/13 Start Qty: 4.00 Cust Item ID: Required Date: 1/30/13 Req'd Qtv: 4.00 Customer: Reference: Run Approvals: Process Plan: Date: Tooling: Date: OC: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Work Center ID Description Run Hours Code Qty Qty Number Stamp 150 Chemical Conversion Coat per QS1005 4.1 0.00 4 2913.2-20 \*150\* HandFinish 0.00 Memo Hand Finishing

155

\*155\* QC

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

Memo

0.00

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

0.00

4 4 13-3-1

4 6 Bl. 13-3-1.

160

\*160\* Powdercoat

Powder Coating

	0.50 92	
NCR:	Yes /	No
ACU.	162 /	IVU

### WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	The state of	e Die
		17971	Section 18

										QA Closed:	Date:				
Work Orde	er:	late .			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Proc	Water Jet I. Eng. Coor.	Engineering Quality			
NCR N					Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Rec/Store/Packaging Other Supplier					
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &					
Cause	Da	te Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
Doc/Data									0	11.446	<b>学</b> 表的传统人				
Equip/Tooling										- "		247 P			
Operator	_									models					
Material	_									- 1		102			
Setup	-	- 1										2112			
Other Process	-									V					
Supplier	-									Nu ze		Y-			
Training										PA					
Unapproved										7.9					
					F/	AULT CATEGORY									
Landir	ng Gear				General				==	100					
4 d	Bend	ng			Bend		Grain			Ovalized		Pressure/Forced			
	Cent	e Not Conce	entric to	O/S	BOM/Route		Hardwa	re	2	Over/Under	tolerance	Temperature/Cure			
	Cracl				Broken/Damaged		Inspecti	on Incomplete	1	Part Incorrec	t	Weld			
		ed/Crimped			Burrs	-		ions Incomplete/	'Unclear	Part Lost/Mis	ssing	Wrong Stock Pulled			
	Cuffs				Contamination	-	Mainte		1/4	Part Moved					
		Treat Countersink					Mislabe			Positioned W		,			
Inspection Strip in Tube Cut Too Short						_	Misread		0 2	Power Loss/S	Surge	Other			
Ripples in Berd Drill Holes							Offset	- 111							
Torque Waves in Extrusion Drawing							Out of Calibration								
		ng Sequence		_	Finish	-		Sequence		1000					
The Caption of	wav	/Twist in Tu	pe		Folio	1	Outside	Dimensions							

QC

Quality Control

Memo

\*95647\*

Page 4

January-16-13 8:34:24 AM Item ID: D4004-041 Accept \*N900040100\* Setup Start Revision ID: Side Restraint Angle Item Name: Start Date: 1/16/13 Start Qty: 4.00 Cust Item ID: Required Date: 1/30/13 Req'd Qty: 4.00 Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 170 QC3- Inspect Part Finish 0.00 \*170\* 4 QC 0.00 Memo Quality Control 180 0.00 \*180\* Small Fab 0.00 Memo Small Fab Assemble as per dwg 190 QC5- Inspect part completeness to step on W/O \*190\*

WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Skid-tube Crosstube Water Jet Engineering Rework Quality Part No. Scrap Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Other Thermoforming Finishing Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Root Initial Action Sign & or Non-conformance Chief Eng Date Verification Cause Date Step Qty Description QC Inspector Doc/Data Equip/Tooling Operator Material Setup Cither Process Sapplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Pressure/Forced Bending Ovalized Grain BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped Burrs Instructions Incomplete/Unclear Wrong Stock Pulled Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Power Loss/Surge Other Cut Too Short Misread Drill Holes Ripples in Bend Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

QC

Quality Control

\*95647\*

Page 5

Insp.

Stamp

January-16-13 8:34:24 AM Item ID: D4004-041 Accept \*N900040100\* Setup Start Revision ID: Item Name: Side Restraint Angle Start Date: 1/16/13 Start Qty: 4.00 Cust Item ID: Required Date: 1/30/13 Req'd Qty: 4.00 Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Accept Reject Work Center ID Description Run Hours Code Qty Qty Number 200 Identify as per dwg & Stock Location: \*200\* Packaging Memo 0.00 Packaging 210

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

	10-11 (01	
VCR:	Yes /	No

### WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

								The state of the s		QA Closed:	Date:				
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	lo				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- 140 m 2 m 1	Water Jet I. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update	Ji	nitial	Ac	tion	Sign &	Maria California				
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ief Eng	Desc	cription	Date	Verification	QC Inspector			
oc/Data										Y 198 a 1					
quip/Tooling										5.6					
perator										77					
Material															
etup															
Other															
rocess	_									18 P					
upplier										200					
Training															
Inapproved							T CATE	CORV	1,115			P			
15541						AUL	T CATE	GURY		There is a					
Landir	ng Gear				General		~====			70		7			
	Bending	Not Conce	atric to	0/5	Bend BOM/Route	-	Grain Hardwa	221	-	Ovalized		Pressure/Forced			
	Cracks	vot conce	ntric to	0/5	Broken/Damaged	$\vdash$			-	Over/Under I		Temperature/Cure Weld			
		I/Crimped		-		-		on Incomplete	/Usalasa		ALC: NO STATE OF THE PARTY OF T	Wrong Stock Pulled			
	Cuffs	/Crimpeu		-	Burrs Contamination	-	Mainte	ions Incomplete,	Onciear	Part Lost/Mis	ising	Twitong Stock Pulled			
	Heat Tr	aat		-	Countersink	-	Mislabe		-	Positioned W	rong Pil				
		on Strip in	Tube	-	Cut Too Short	$\vdash$	Misread		10-00	Power Loss/S	-	Other			
	Ripples		Tube		Drill Holes	$\vdash$	Offset	*		Trower coss/s	Mige.	Other			
		Waves in	Extrusio	_	Drawing	-		Calibration		- 12 Tel					
		Sequence		V	Finish	-		Sequence		- 33		Tagette A			

Outside Dimensions

Wave/Twist in Tube

H: FORMS/Quality Assurance\approved QA/NCRWO Rev G

### · Picklist Print

January-16-13 8:34:28 AM

Work Order ID: 95647

Parent Item:

D4004-041

Parent Item Name: Side Restraint Angle

\*95647\*

\*D4004-041\*

Start Date: 1/16/13

Required Date: 1/30/13

Start Qty: 4.00

\*\*

Loc Code

Required Qty: 4.00

Comments:

IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as

	per dwg rev.b DD		1.0	TPI	Rev:C 12,03.0	D7 as							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	st	212.7400	0.22	0.926316			
*M2024T: 2024-T3 .063 sheet	35 063*								**	1			Jm13-20
12				Location	ì	Lo	e Qty	Loc Code					
				MAT022			212.74						
					119916		0.2		-				
					121197 123096		21.34						
					123654		11.4		-				
					123701		167		1	23701			
D4004-3		Manufactured	No			180	Each	3.0000	1 -1	4			
*D4004-3 Strut Lock Bracket	*								**		F	FU	-03-13
				Location		Loc	Qty	Loc Code					
				GA			3						
D4004.7					80021		3			3			
D4004-7		Manufactured	No			180	Each	40.0000	1	4			

\*D4004-7\* Hose Clip

> Location Loc Qty GA 40 79992 85482 39

FF 13-03-13

NCR: Y	es / No				WORK ORDER NON-C	ON	FORM	MANCE / UP	DATE	QA Closed:	Date:	NA.	
Work Orde Part N NCR N	0.				DISPOSITION  Rework  Scrap  Use-as-is  Work Order Update	ě	Therm	Skid-tube Machining noforming Large Fab	AGAINST DE Crosstube Small Fab Finishing Composite	DEPARTMENT/PROCESS  Water Jet Engineering Quality Rec/Store/Packaging Supplier  DEPARTMENT/PROCESS  Water Jet Engineering Quality Other			
Root	T			Descri	otion of work order update	In	nitial	Act	tion	Sign &	~W. F.Z. (3)		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						ULT	CATE	GORY	E VI				
Landin					General				100				
	Bending Centre No Cracks	ot Concer	ntric to C	0/5	Bend BOM/Route Broken/Damaged		Grain Hardwa 'nspecti	re on Incomplete		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure Weld	
	Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mis	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	-	Mainte		12	Part Moved			
	Heat Treat Countersink					-	Mislabe		91	Positioned W			
	Inspection Strip in Tube Cut Too Short					Misread Power Loss/Surge Other					Other		
	Ripples in Bend Drill Holes						Offset						
	Torque W	aves in E	xtrusion		Drawing	Out of Calibration							
2	Turning S	equence			Finish		Out of S	equence					

Outs de Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

### · Picklist Print

January-16-13 8:34:28 AM

Work Order ID: 95647

Parent Item:

D4004-041

Parent Item Name: Side Restraint Angle

MS20426AD4-4

Purchased

No

No

\*MS20426AD4-4\*

Rivet

MS20426AD4-5

Purchased

\*MS20426AD4-5\*

\*95647\* \*D4004-041\*

Location

121090

GA

Start Date: 1/16/13

Start Qty: 4.00

4

\*\*

Loc Code

806.0000

Loc Qtv 806

806

Hach

Fach

2,700,000

\*\*

FF 13-03-13

FF 13-03-13

Required Date: 1/30/13

Required Qty: 4.00

Location Loc Qty Loc Code GA 48 6874 48 ST317 2652 6874 2652

180

180

January-16-13 8:34:28 AM

Shop Packet Print

Page 2

QA Closed: Date:	
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	
	ngineering
Part No. Scrap Machining Small Fab Prod. Eng. Coor.	Quality
Use-as-is Thermoforming Finishing Rec/Store/Packaging	Other
NCR No Work Order Update Large Fab Composite Supplier	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification	QC Inspector
Doc/Data	
Equip/Tooling	
Operator	
Material	
Setup	A STATE OF
Other	- 4 35
Process	
Supplier Training	
Lnapproved	
FAULT CATEGORY	
Landing Gear General	V. (1964)
Bending Bend Grain Ovalized Pre	essure/Forced
Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Te	mperature/Cure
Cracks Broken/Damaged Inspection Incomplete Part Incorrect We	
	rong Stock Pulled
Cuffs Contamination Maintenance Part Moved	
Heat Treat Countersink Mislabeled Positioned Wrong	
	her
Ripples in Bend Drill Holes Offset	
Torque Waves in Extrusion Drawing Out of Calibration	
Turning Sequence Finish Out of Sequence  Wave/Twist in Tube Folio Outside Dimensions	W #15

DQA:

Date:

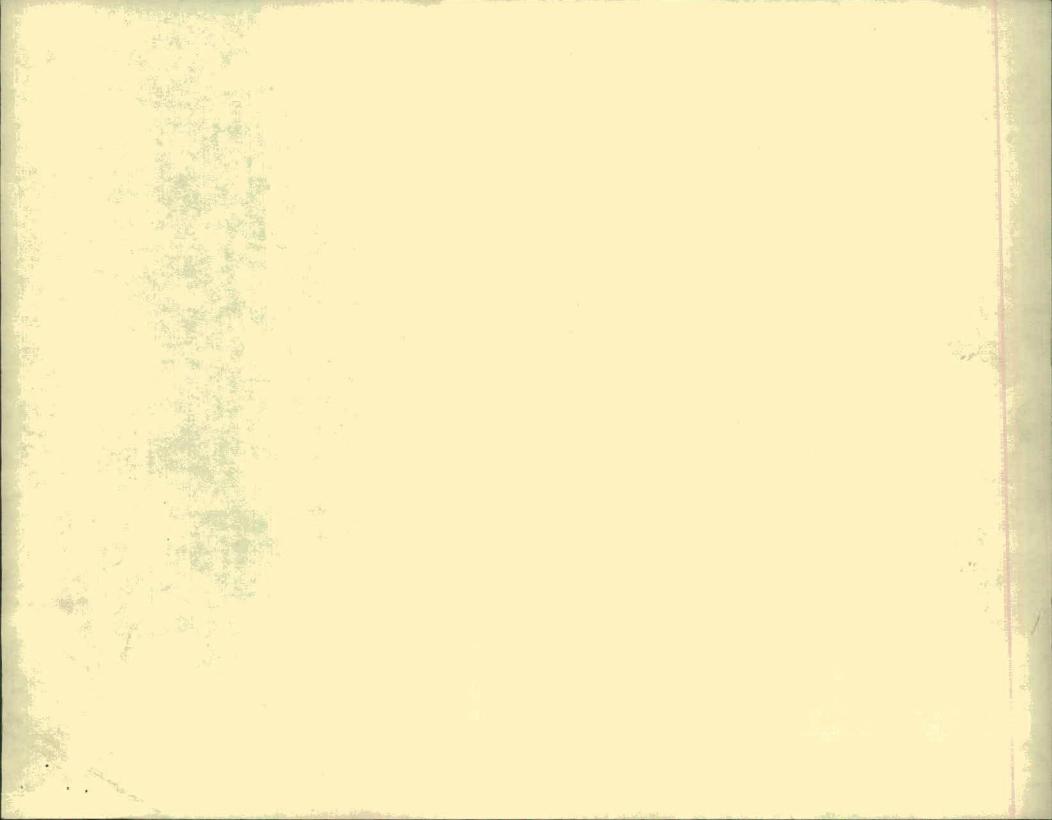
DART AEROSPACE LTD	Work Order:	95647
Description: Side Restraint	Part Number:	D4004-1
Inspection Dwg: D4004 Rev: A B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

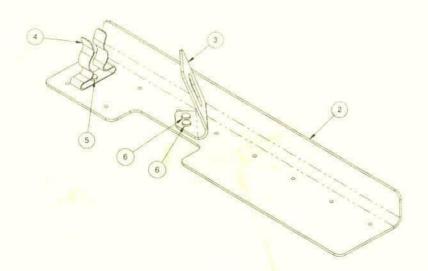
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.1098"	=		V	Jemoi
Ø0.129	+0.005/-0.001	0.128"	-		V	7
3.65	+/-0.030	3.650"	=		V	
0.223	+/-0.010	0.223"	-		V	
10.63	+/-0.030	10.631	-		V	Produter
2.99	+/-0.030	3000	-		V	1,000
5.79	+/-0.030	5,787"	-		V	
0.87	+/-0.030	0.868"	L		V	
2.40	+/-0.030	2-397"	-		V	_
1.38	+/-0.030	1.381"	~		V	
0.50	+/-0.030	0.499"	<b>E</b>		ν	
0.79	+/-0.030	0.786	_		V'	
0.38	+/-0.030	0.379"	=		V	
0.98	+/-0.030	0,986"			V	
1.18	+/-0.030	1.185"	-		V	
1.56	+/-0.030	1.558	-		V	
0.063	+/-0.010	0.061"	k=		V	
					1	
			JAS	1		

			15		
Measured by:	Im	Audited by:	- 59	Preliminary Approval:	N/A
Date:	3-2-8	Date:	13.2-8	Date:	N/A

Rev	Date	Change		Revised /b/y	Approved
Α	10.08.03	New Issue	P/O D4004-041	ку 😽	A)
				1/4	- FALL



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	•
6	2	MS20426AD4-5	RIVET	



95647 MLJ 13-01-16

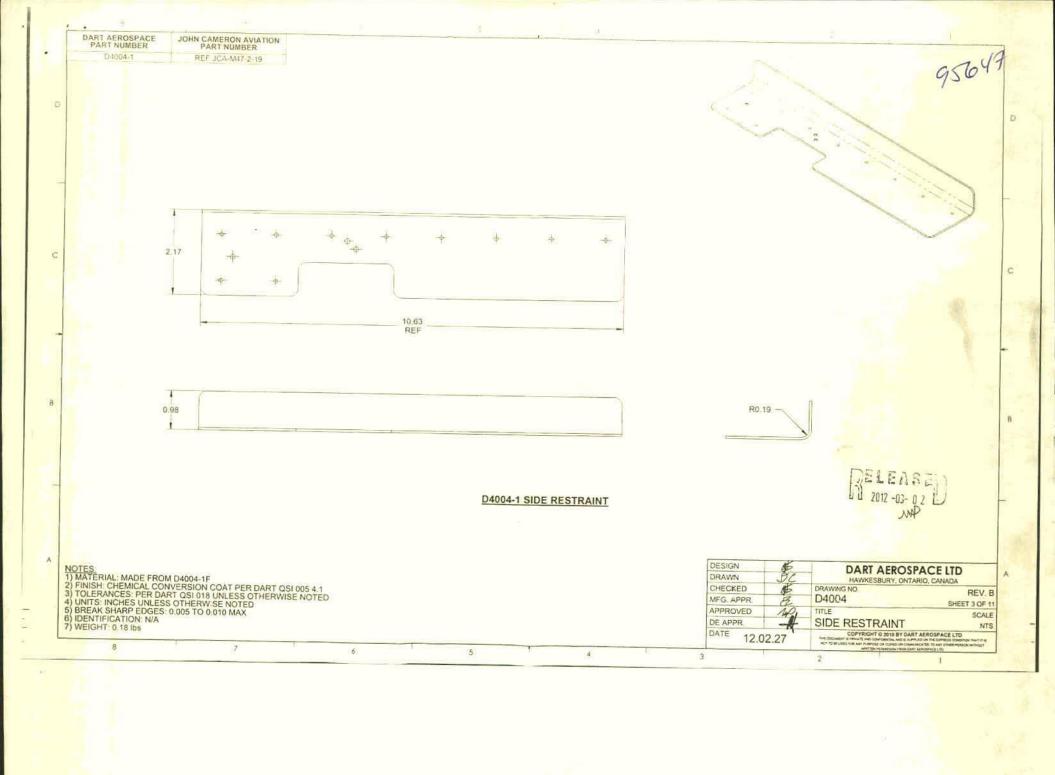
DELEASED 2012 -03- 0 2012

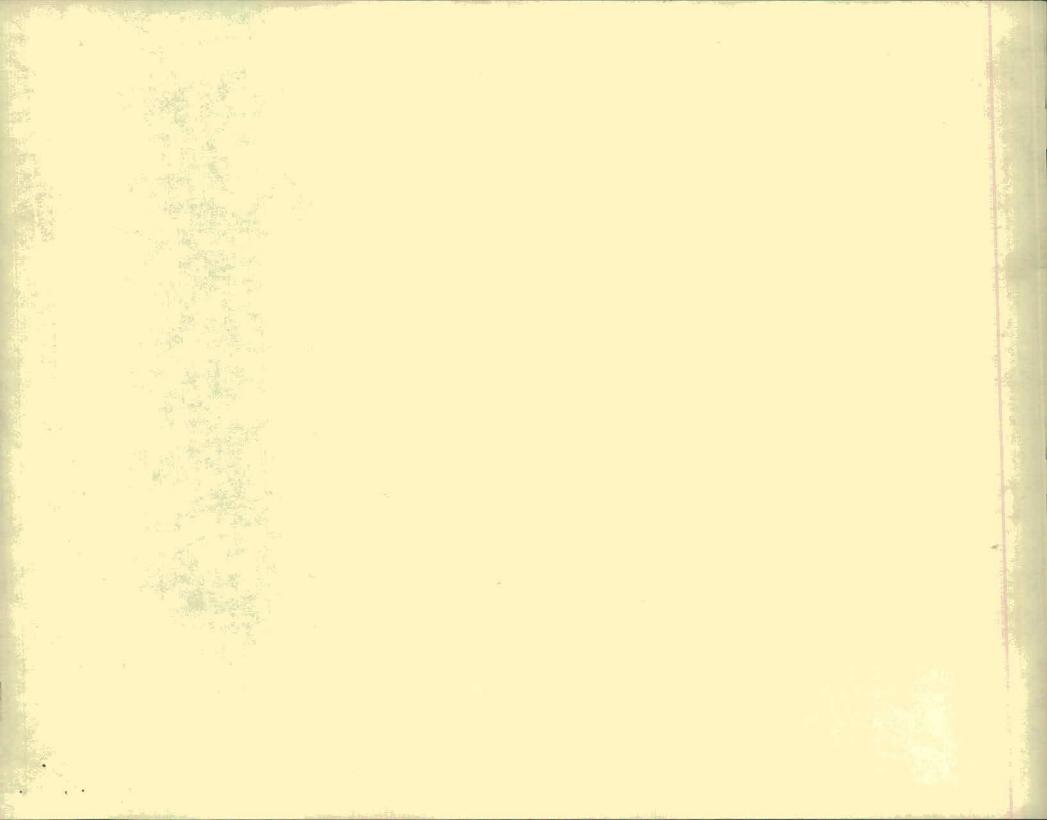
#### D4004-041 SIDE RESTRAINT ANGLE

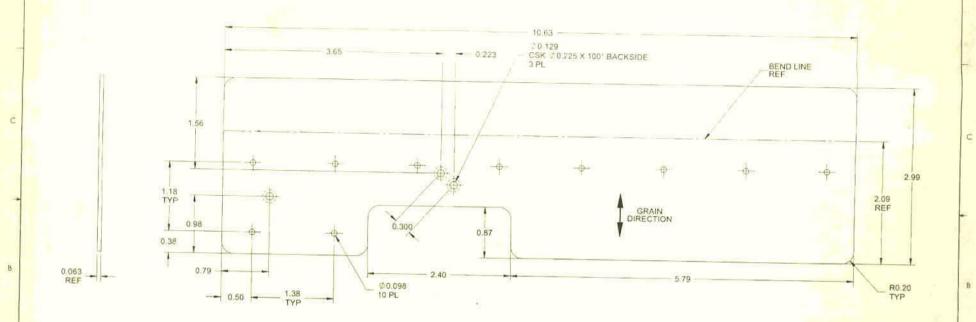
NOTES

1) MATERIAL: N/A
2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.21 lbs

CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN AB-1, ZN AB-2. 12.02.27 A NEW ISSUE HS. 10.02.10 REV DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D4004 MFG, APPR. SHEET 1 OF 11 APPROVED TITLE SCALE DE APPR SIDE RESTRAINT NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD DATE 12.02.27





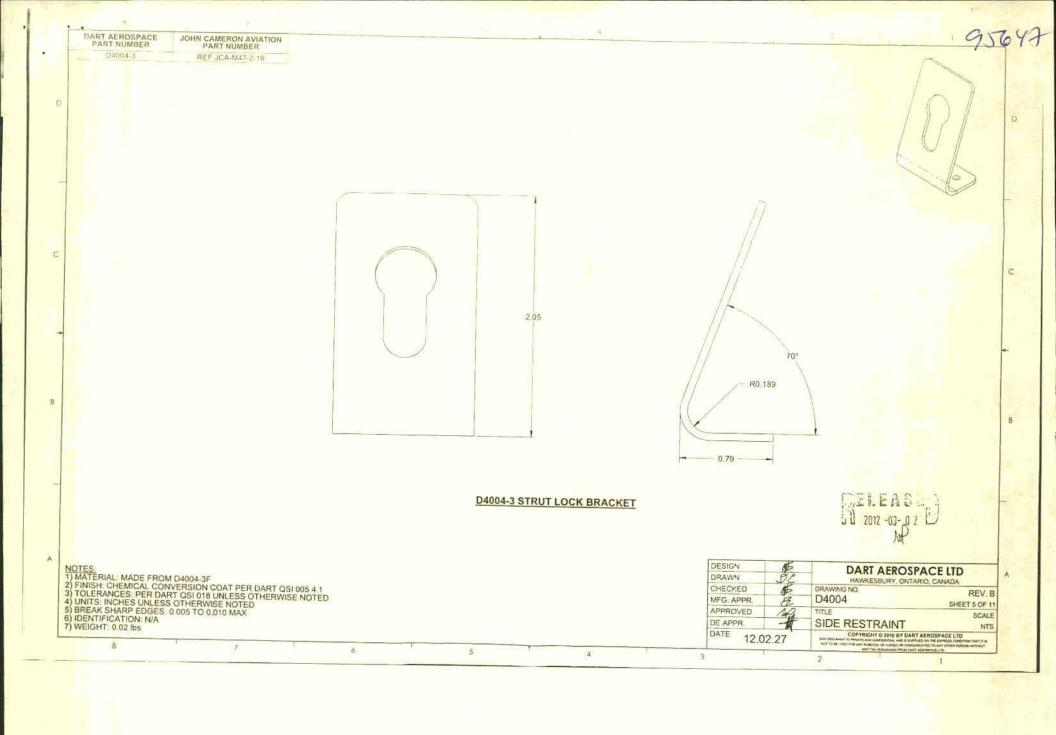


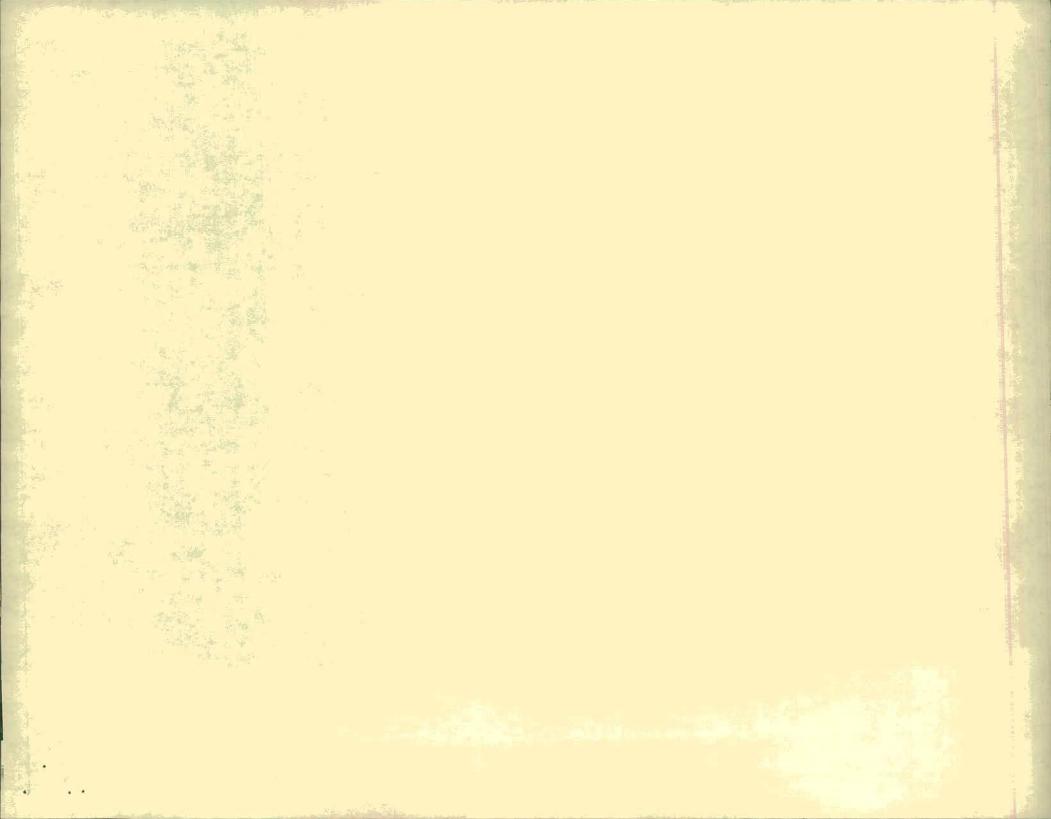
D4004-1F FLAT PATTERN

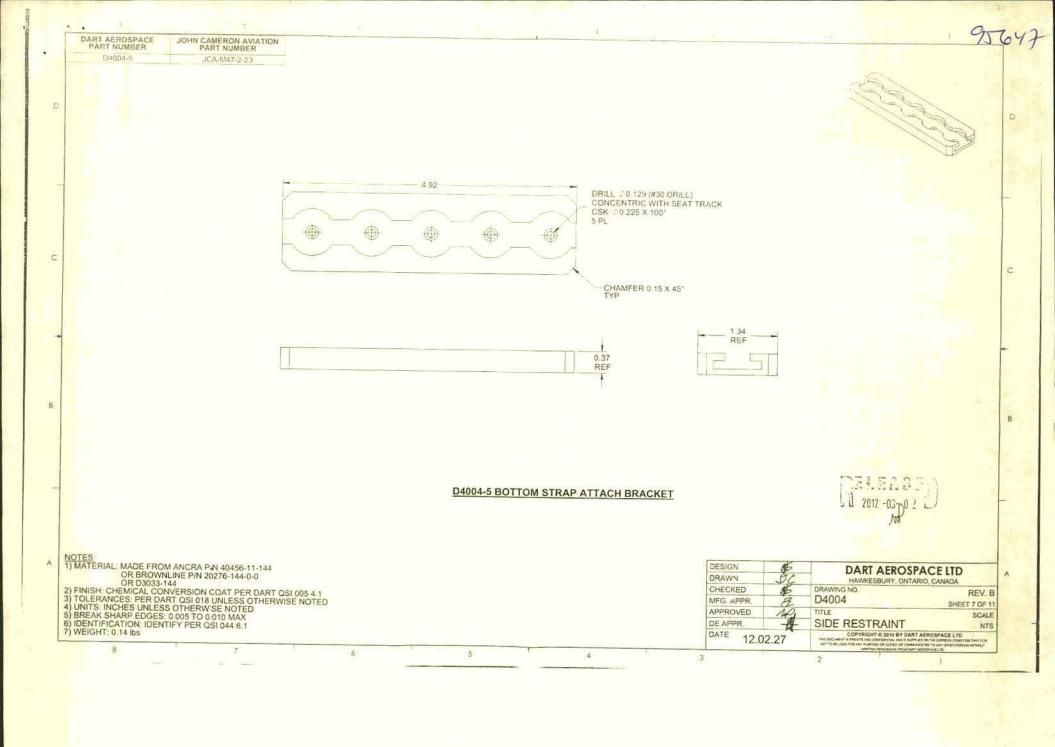
3

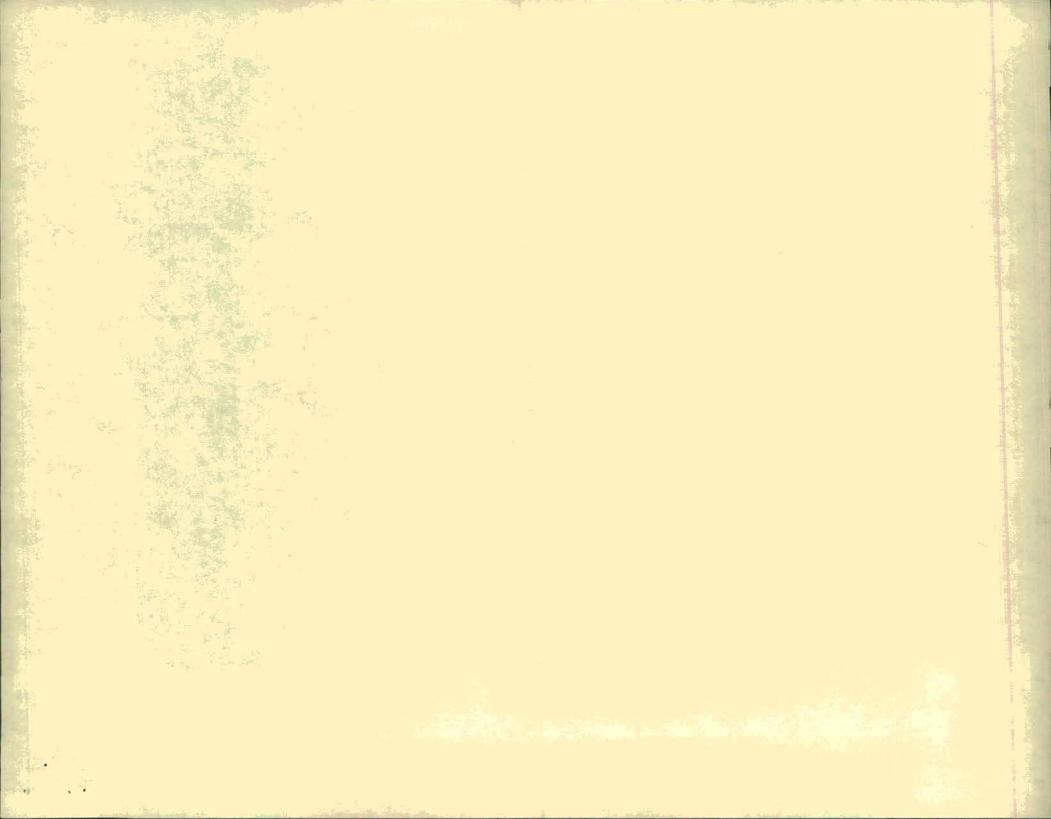
NOTES: 1) MATERIAL. 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063 REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B MFG. APPR. D4004 SHEET 4 OF 11 APPROVED TITLE SCALE SIDE RESTRAINT DE APPR NTS DATE COPYRIGHT © 2016 BY DART AEROSPACE LTD 12.02.27





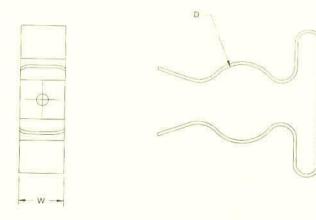




DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-7	N3 REF JCA-M47-2-19

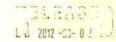
## SPECIFICATION CONTROL DRAWING





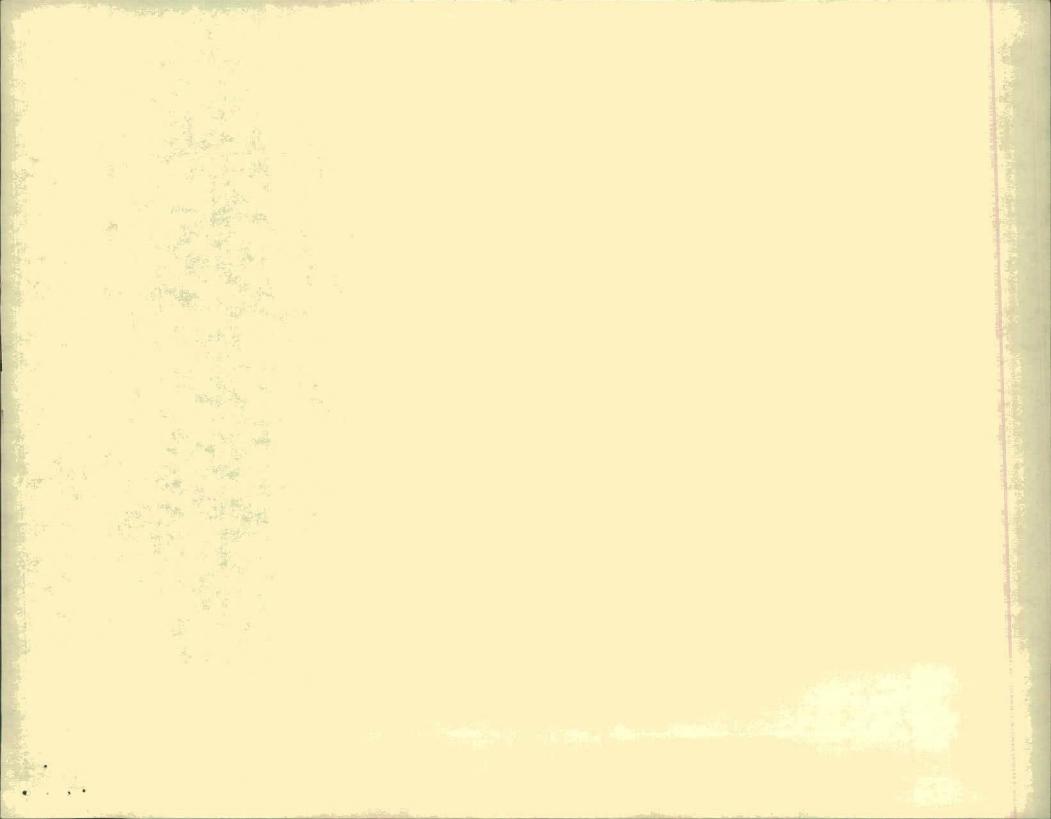
DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE Ø	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

### D4004-X HOSE CLIP



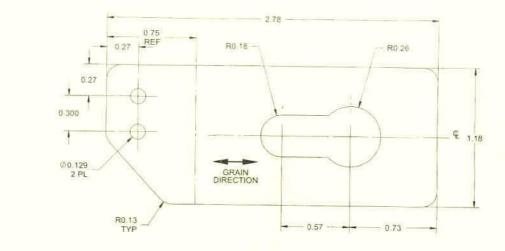
ı.	NOTES
	1) MATERIAL: SEE TABLE
	2) FINISH: N/A
	3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
	4) UNITS: INCHES UNLESS OTHERWISE NOTED
	5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
	6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
	7) WEIGHT 0.01 lbs

DESIGN	35	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO	
CHECKED	15	DRAWING NO.	REV. B
MFG. APPR.	8	D4004	SHEET 8 OF 11
APPROVED	1491	TITLE	SCALE
DE APPR.	#	SIDE RESTRAINT	NTS
DATE 12.0	2.27	COPYRIGHT © 2010 BY DART AER THIS DOCUMENT IS PRINCIPLATED ON CONTROL OF CONT	THE EMPLESS CONSTRUCTION THE TIT IS TO MAY ETHING PERSON WITHOUT



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D4004-3F FLAT PATTERN

5

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QO-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063

2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.02 lbs

7

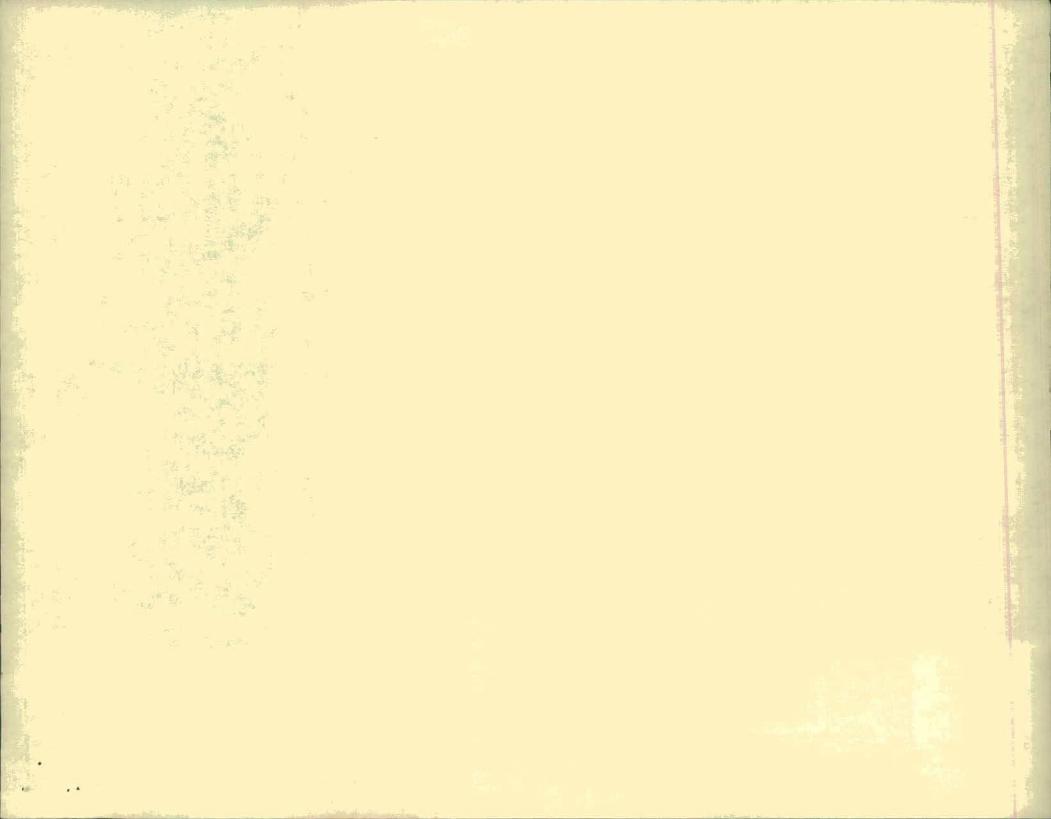
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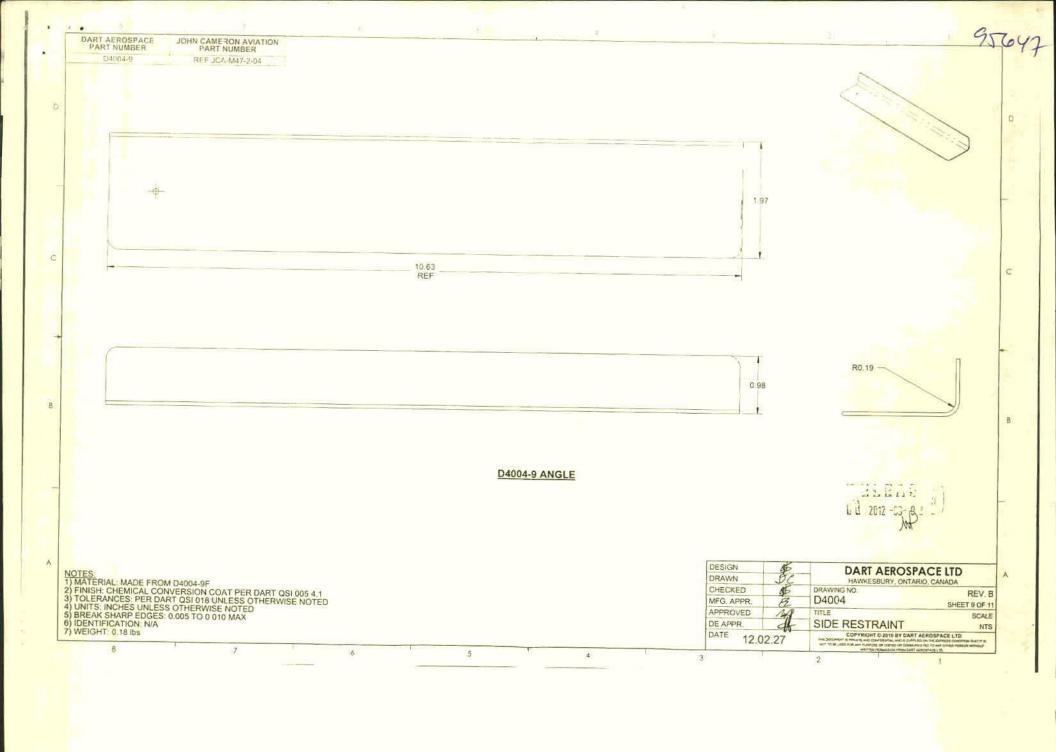
0.063

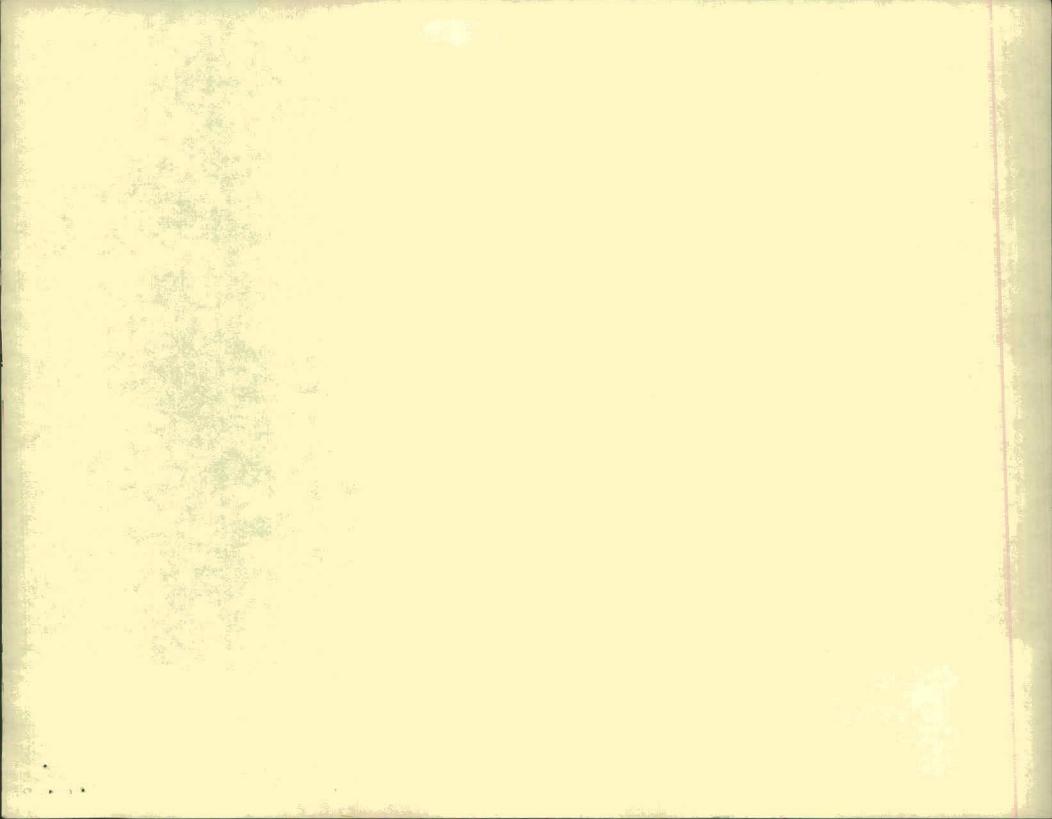
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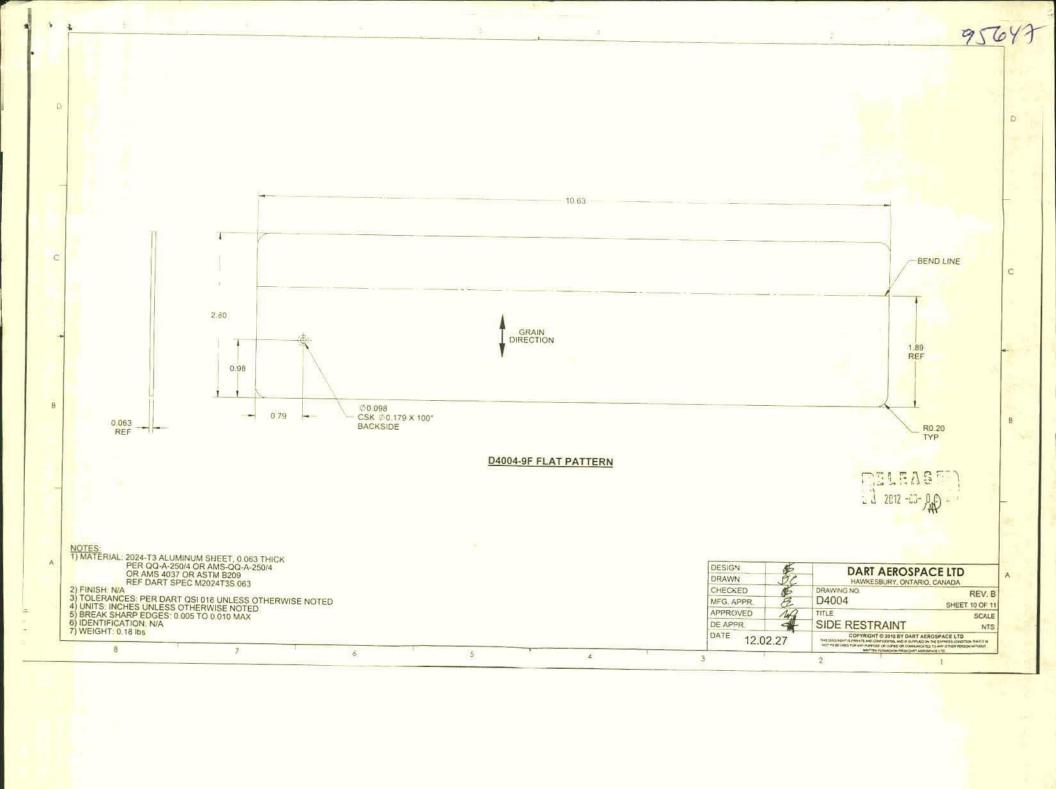
DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B MFG. APPR. D4004 SHEET 6 OF 11 APPROVED TITLE SCALE SIDE RESTRAINT DE APPR NTS DATE COPYRIGHT IS 2010 BY DANT AEROSPACE LTD 12.02.27

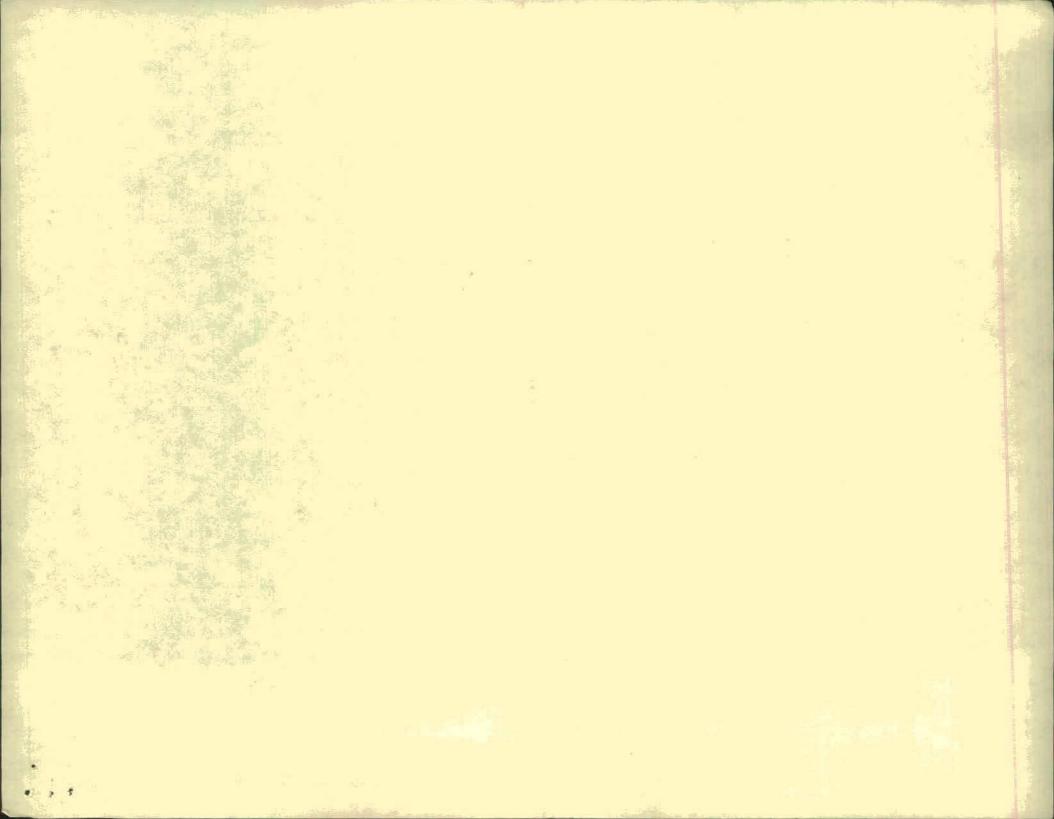
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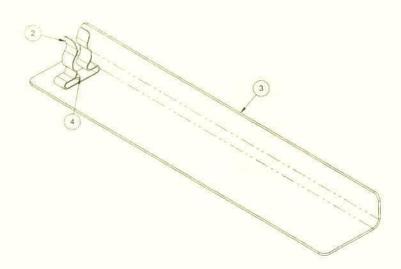




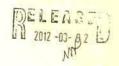
ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-7	HÖSE CLIP	
3	- 1	D4004-9	ANGLE	
4	1	MS20426AD4	RIVET	



В



### D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT



NOTES:		
1) MATERIAL: N/A	COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005.4.3	A
3) TULERANCES PI	ER DART QSI 018 UNLESS OTHERWISE NOTED	B
4) UNITS: INCHES U	INLESS OTHERWISE NOTED	
6) IDENTIFICATION:	DGES: 0.005 TO 0.010 MAX IDENTIFY PER QSI 044 6.1	
7) WEIGHT: 0.20 lbs		

DESIGN	1	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO	
CHECKED	15	DRAWING NO.	REV. B
MFG, APPR	8	D4004	SHEET 2 OF 11
APPROVED	143	TITLE	SCALE
DE APPR	-#	SIDE RESTRAINT	NTS
DATE 12.0	2.27	COPYRIGHT © 2010 BY DART AS: THE DECAMENT A PRIVATE AND CONTROL OF COMMAND AS THE THE TOP ANY PLANTED OF COMMAND AS THE PRIVATE AND THE PRIVAT	WITH FARTH WORKSHOOD BESTFEET WITH

